

Date: Tuesday, 23/12/2008 12:53:39 PM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RADIUS BLOCK
Job Number : 44289	
Estimate Number : 12813	
P.O. Number :	Part Number : D36011
This Issue : 23/12/2008 S.O. No. :	Drawing Number : D3601 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 39766	Material :
Written By :	Due Date : 10/01/2009 Qty: 50 Um: Each
Checked & Approved By :	
Comment : Est Rev:A New Issue 07-03-28 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0750X00125	6061-T6 Bar .750 x .125
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Comment: Qty.: 0.0962 f(s)/Unit Total: 4.8090 f(s)
 6061-T6 Bar .75" x .125"

Material: 6061-T6 (QQ-A-250/11) or 5052-H34 (QQ-A-250/8) 1/8" X 3/4" BarBatch M109760

m 09/01/09

(64)

2.0	SHEAR	SHEAR
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Comment: SHEAR
 Shear blanks 9.00" long +/- 0.030"
 Note: 1 blank makes 8 pieces

m 09/01/09

(64)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA682 Rev: AA & Dwg D3601 Rev: A

(54)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

m 09/01/09

(54)

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.L 09/01/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



SSX counted

Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

Deburr any rough edges after tumbling

→ M-L 09/01/16

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

gt 09-01-20

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



55

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09/01/20

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 115

FL 09/01/20 (55)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



09/01/21

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



h 09.01.20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

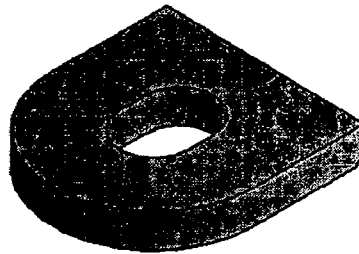
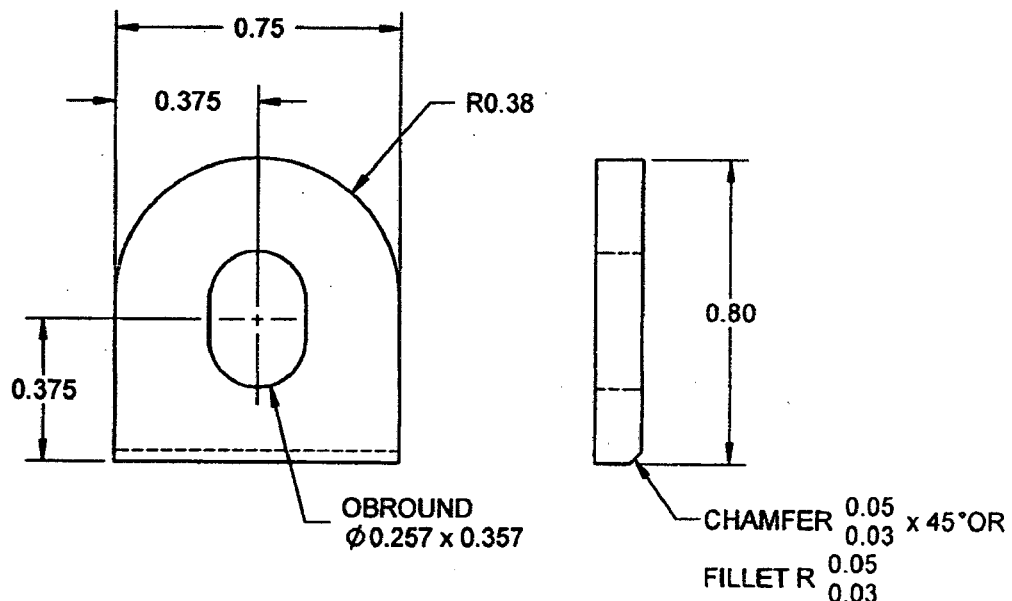
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CB	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3601	REV. A SHEET 1 OF 1
DATE 07.02.13		TITLE RADIUS BLOCK	SCALE 2:1
REV A	DATE 07.02.13	DESCRIPTION NEW ISSUE	

RELEASED07.03.08 *[Signature]**u/o 44289***D3601-1 RADIUS BLOCK****NOTES:**

- 1) MATERIAL: ALUMINUM 5052-H32 SHEET, 0.125 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.125) OR ALUMINUM 6061-T6 SHEET, 0.125 THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3601-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.050 MAX

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